

Date: Tuesday, 17/02/2009 10:18:38 AM
 User: Julie Dawson

Process Sheet

ASA P.

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOOR WINDOW
Job Number	: 45819		
Estimate Number	: 10848		
P.O. Number	:	Part Number	: D3295041
This Issue	: 17/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3295 REV D
First Issue	: / /	Project Number	: N/A
Previous Run	: 45707	Drawing Revision	: D
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/03/2009
Checked & Approved By	: <u>Julie Dawson 09-02-17</u>	Qty:	6 Um: Each
Comment	: Est. C 05.06.20 D3295-1 no longer made in-house KJ/JLM Est Rev:D Added DT8822 07-03-20 JLM Est Rev:E Returned Manufacturing In House 07-06-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	MLEXS125 9034 01	1/8" 9034 Lexan Sheet
-----	------------------	-----------------------



MAT NOT PULLED



Comment: Qty.: 1.3020 sf(s)/Unit Total : 7.8120 sf(s)
 1/8" Thick Lexan 9034 sheet
 Batch: 106403 18 9-2-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3295
 Dwg Rev: D
 Prog Rev: D

18 9-2-22

2-Remove plastic and wrap in saran wrap.

2-Deburr if necessary

(9) (8)
 (P) →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



18 9-2-22

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE


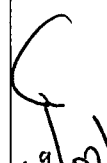





4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 09/02/23 (6) (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: N/A Fault Category: Prod/Asy mcl & small NCR: (Yes) No DQA: D Date: 09/04/29
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/04/29

NCR: <u>45819</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/23	# 2.0	one (qty 1) window found with many scratches on both surfaces PC storage and transport, from w.a.s.	 J. Smith	SCRAP and Destroy and replace no replace extra made	 09/08/23	 09/02/23	 J. Smith	S 09/06/23
			 J. Smith			 09-02-23	 J. Smith	6 09/06/23

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:38 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 45819

Part Number: D3295041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3295.

Put window in plastic wrap.

SAD

09-09-27

(7)

6.0

D27281

Dart Logo label



Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

Dart Logo label small

Pick:

Qty

Part Number

Description

Batch

1

D2728-1

Decal

339012

SAD 09-04-27

(3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/04/27

(X6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 212

A 09/04/27

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/28

Job Completion



mf 09-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3295-041 PAR #: N/A Fault Category: Prod/FAZ Assembly ^{Small} NCR: Yes No DQA: D Date: 09/04/29
 Resolution: SCIAP Disposition: SCIAP QA: N/C Closed: D Date: 09/04/29

NCR: 45819		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
7/4/27	# 6.0	Qty (41) window Panels with loose scratches bc sitting since Feb. in Lunch Room	AD 02/04/27	Scrap and destroy no replace	SAD 02/04/27	S 02/04/27	AD 02/04/27	S 02/04/27

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45819
Description: Window		Part Number: D3295
Inspection Dwg: D3295 Rev: D		Page 1 of 1

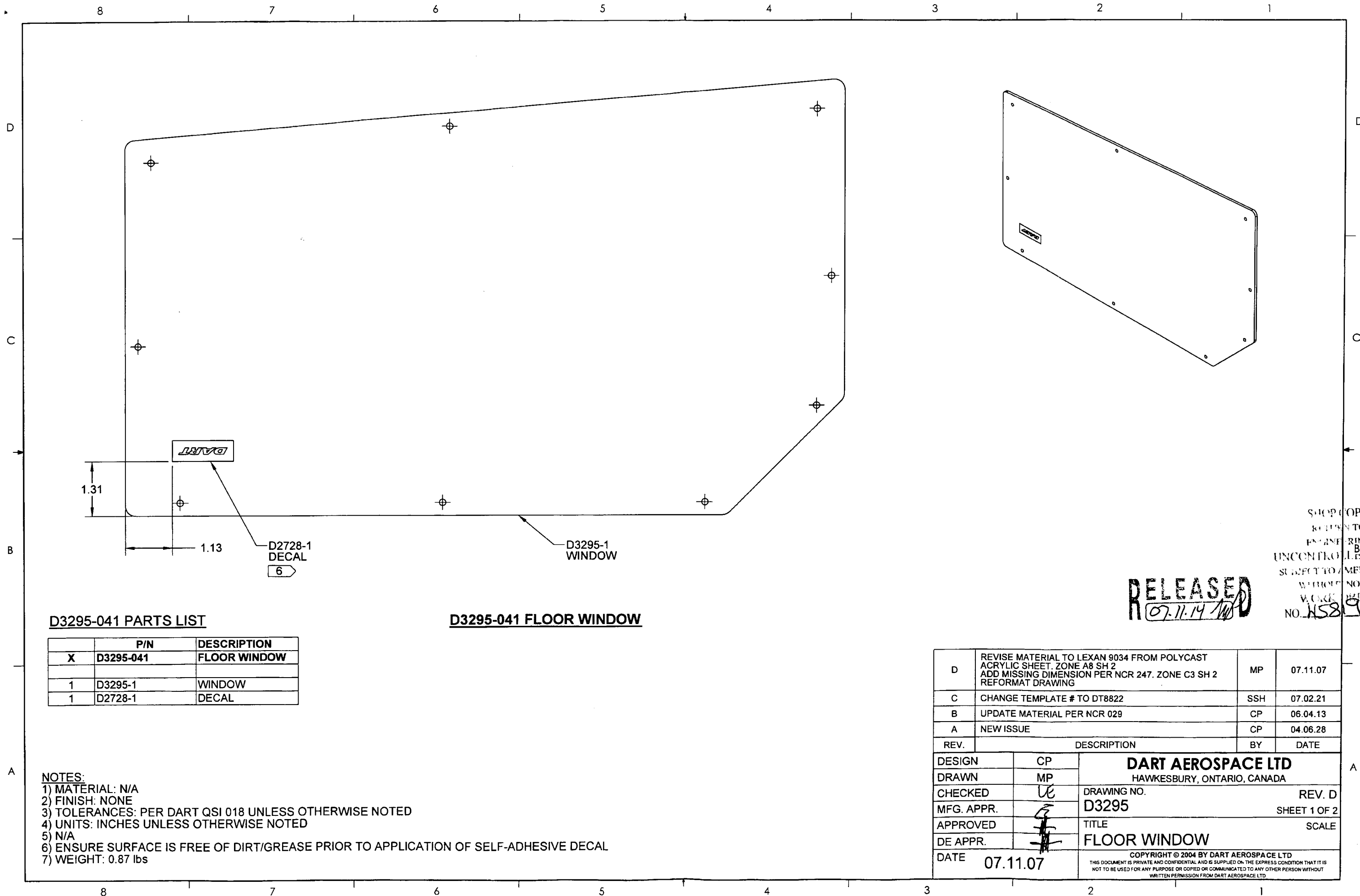
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

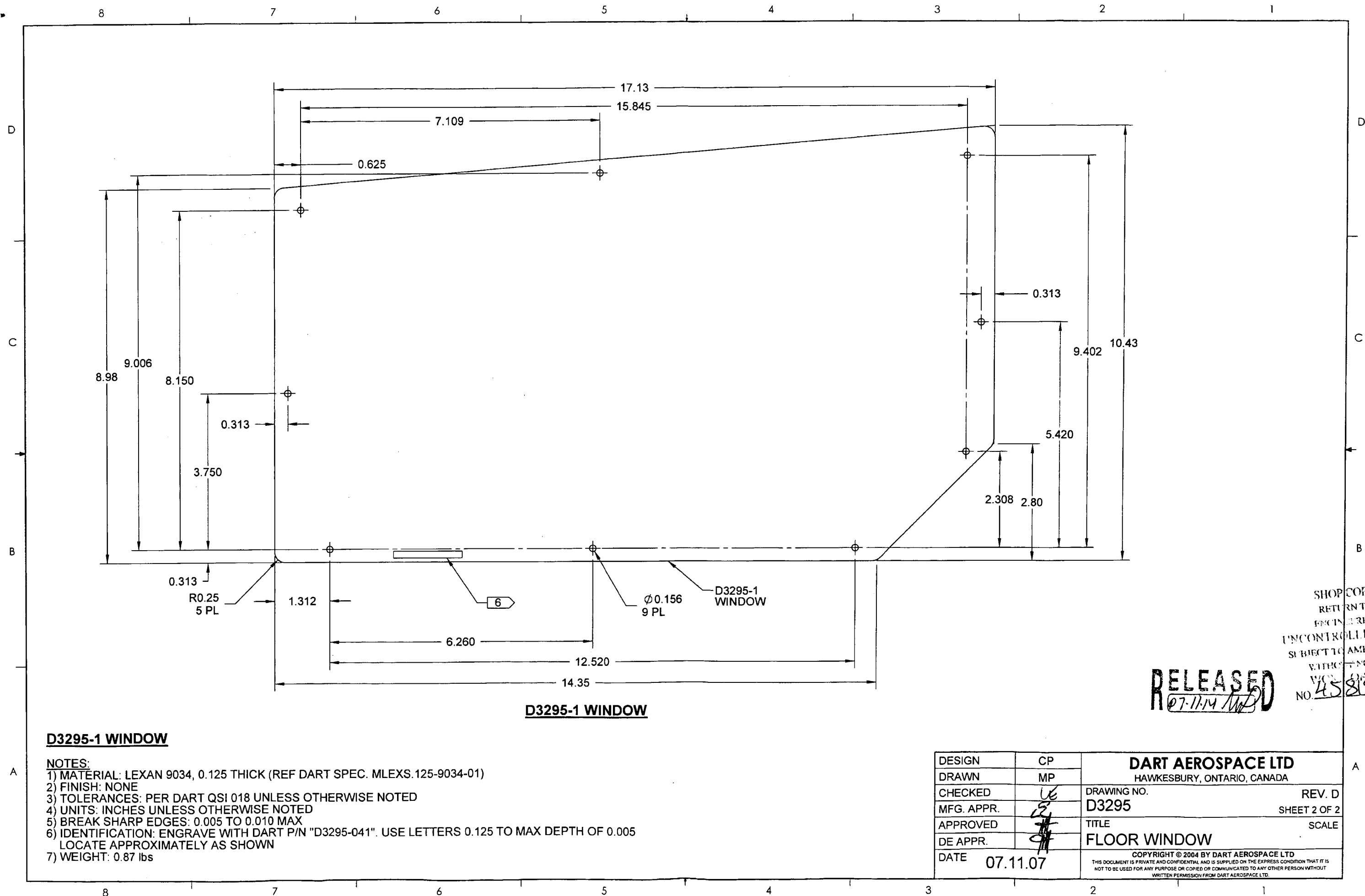
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.156	+0.005/-0.001	.158	✓			
17.13	+/-0.030	17.13	✓			
10.43	+/-0.030	10.43	✓			
14.35	+/-0.030	14.35	✓			
8.98	+/-0.030	8.98	✓			
0.625	+/-0.010	.621	✓			
7.109	+/-0.010	7.111	✓			
15.845	+/-0.010	15.845	✓			
2.308	+/-0.010	2.310	✓			
5.420	+/-0.010	5.417	✓			
9.402	+/-0.010	9.402	✓			
1.312	+/-0.010	1.314	✓			
6.260	+/-0.010	6.261	✓			
12.520	+/-0.010	12.520	✓			
0.313	+/-0.010	.308	✓			
3.750	+/-0.010	3.747	✓			
8.150	+/-0.010	8.146	✓			
9.006	+/-0.010	9.009	✓			
0.125	+/-0.010	.123	✓			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-2-23	Date: 09/02/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue P/O D3295-041	KJ/EC/DD	✓



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 15819



D3295-1 WINDOW

NOTES:

- 1) MATERIAL: LEXAN 9034, 0.125 THICK (REF DART SPEC. MLEXS.125-9034-01)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3295-041". USE LETTERS 0.125 TO MAX DEPTH OF 0.005
LOCATE APPROXIMATELY AS SHOWN
- 7) WEIGHT: 0.87 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45819

RELEASED
07-11-14